

Work Order ID 153085

Tuesday, November 08, 2016 10:52:04 AM

153085

Page 1

Item ID: D4151-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Eyebolt Receiver (Upper)
Start Date: 11/24/2016 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 12/2/2016 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **NOV 09 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4151	C

100

0.00

100

Bandsaw

Memo

0.77

Jeaspa Bandsaw

Cut blank to 2.960" long

DAS
45 16-11-28
9-89

16 0

110

0.02

110

HAAS 1

Memo

1.09

HAAS CNC vertical machine #1

1-MILL as per folio FA952 & dwg,
FOLIO REV: AA
DWG REV: C

2-Deburr as required

DAS
20 16-11-30
9-89
DAS
45 16-12-01
9-89

16 1

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Setup Start *NS1*

Stop *NS2*

Start Date: 11/24/2016 **Start Qty:** 16.00

Required Date: 12/2/2016 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.03

QC

Memo

Quality Control

DAS
20 16-11-30
9-89
DAS
45 16-12-01
9-89

130 QC8- Inspect parts - second check

0.00

130

0.05

QC

Memo

Quality Control

DAS
14
9-89
11/12/02

140 Identify as per dwg & Stock Location: Store

0.00

140

0.03

Packaging

Memo

Packaging

16 DAS 6 9-89 DEC 02 2016

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150							DAS 21 9-89	DEC 05 2016	
QC	Memo	0.27							
Quality Control									

ME
16-12-02

Picklist Print

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Work Order ID: 153085

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Parent Item: D4151-7

D4151-7

Parent Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 11/24/2016

Required Date: 12/2/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP
Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303B2.000X1.750

Purchased

No

100

f

5.0262

0.26

4.378947

M303B2 000X1 750

4.6183'

303 BAR 2" X 1.750"

Location

Loc Qty

Loc Code

MAT008

5.0262

m132117

3.9703

m133547

0.6726

m134734

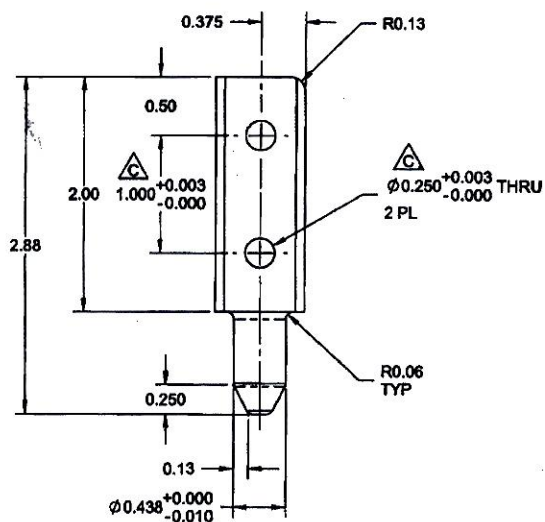
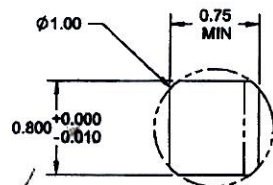
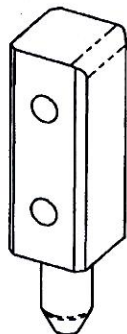
0.3833

1,28 ft + .255' S.F. 16-11-29
2,70 ft
0,383 ft

4,363 ft

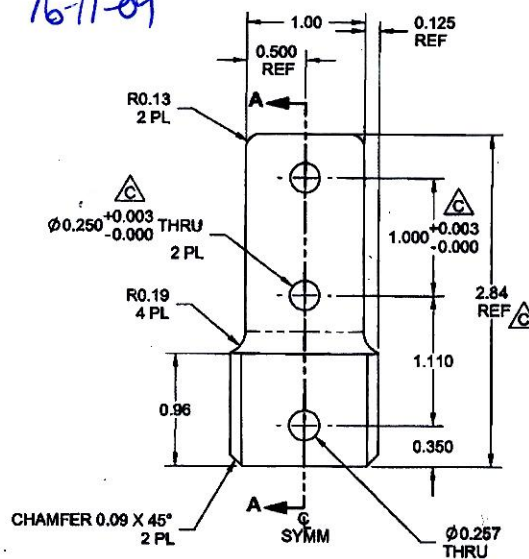
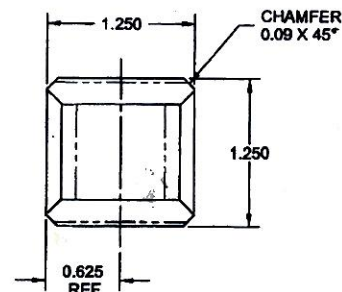
DAS
45
9-89

16-11-28

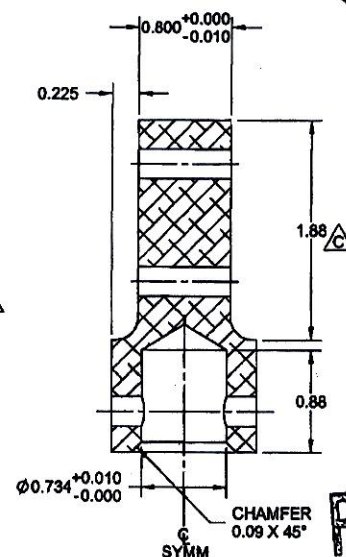
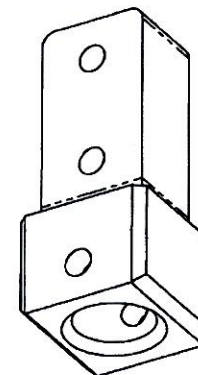


D4151-5 FWD BASKET INSTL STUD (LOWER)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153085MLJ
16-11-09



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

RELEASED
2011-09-10
RELEASED

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE
DE APPR.			NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date: DEC 22 2016

Work Order update only ☐

Work Order: <u>153 085</u> Part No. <u>D4151-7</u> NCR No. <u>16-6197</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>16-11-29</u>		Step #: <u>110</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval DAS <u>9</u> 9-89 <u>16-12-08</u>		
Description Work Order Deviation				Disposition				Completed By DAS <u>20</u> <u>16-11-29</u> 9-89	
<u>Drill broke in the Part.</u>				<u>Scrap & Replace</u> <u>B 132 117</u>				Lead hand / Supervisor Approval Verification <u>B</u> <u>16-11-29</u>	
								QC / QA Coordinator Approval DAS <u>9</u> 9-89 <u>16-12-08</u>	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☒ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☒ Misaligned/off center ☐ Turning Sequence ☐							
		OTHER :							